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वस्त्रादि — करघों के लिए  
पिकर्स — विशिष्टि  
( पहला पुनरीक्षण )

**Textiles — Loom  
Pickers — Specification**  
( *First Revision* )

ICS 59.120.30

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## FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Textile Machinery and Accessories Sectional Committee had been approved by the Textiles Division Council.

Picker is used to drive the shuttle from one box to another. While entering the box it also sustains the force of the shuttle.

This standard was originally published in 1977. The standard has again been revised to incorporate the following changes:

- a) References to Indian Standards have been updated; and
- b) Marking clause has been modified.

The composition of the Committee responsible for the formulation of this standard is given in Annex B.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***TEXTILES — LOOM PICKERS — SPECIFICATION***( First Revision )***1 SCOPE**

This standard covers tolerance on dimensions and mass and requirements for workmanship, finish, etc, of loom pickers made of leather, rawhide, synthetic rubber, plastics, etc.

**2 REFERENCES**

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of these standards.

**3 MATERIAL****3.1 Raw-Hide or Leather Pickers**

**3.1.1** Only fully seasoned (natural/vacuum impregnated in sperm oil), stout and heavy buffalo hide-free from sun burns, putrefaction, etc should be used.

**3.1.2** The chemicals used for dehairing shall not impair the strength of hide.

**4 DIMENSIONS AND MASS**

**4.1** The mass, length, width, thickness, slot width or spindle hole, diameter, etc, shall be as given in IS 1906 unless otherwise specified in the contract.

**4.2** The following tolerances shall be applicable to the dimensions and mass of the picker:

<i>Sl No.</i>	<i>Characteristics</i>	<i>Underpick Loom Picker</i>	<i>Overpick Loom Picker</i>
(1)	(2)	(3)	(4)
i)	Overall length, width and thickness (to the nearest 0.1 mm)	+ 0 – 2 percent	± 5 percent
ii)	Slot width, mm	+ 0 – 2 percent	—
iii)	Spindle hole diameter	—	Clearance of + 1.0 – 0.0 mm over the corresponding spindle diameter
iv)	Mass (to the nearest gram)	± 4 percent	± 5 percent

**5 WORKMANSHIP AND FINISH**

**5.1** At slots, edges, corners and exposed surfaces, the picker should be free from sharp edges and rough surfaces.

**5.2** The fasteners (staples, rivets, beyond the surface of picker etc) should not unnecessarily protrude beyond the surface of picker.

**5.3** No interlayer interstices shall be permitted.

**5.4** The overpick loom picker shall freely slide on

the smooth, polished and straight spindle (*see* IS 7043) of the corresponding diameter. The spindle holes shall be coaxial.

NOTE — To ensure better performance of 4B pickers oval shape may be provided at shuttle tip and striking point in the case of all pickers, and also at spindle bole in the case of leather and raw-hide pickers only.

**6 SAMPLING**

**6.1** A lot shall consist of all the pickers in a consignment made of same material and having same nominal dimensions, shape, mass, etc.

## 6.2 Sampling Plan

The sample size and acceptance number depending upon the lot size shall be as follows unless otherwise specified:

<i>Sl No.</i>	<i>Lot Size</i>	<i>Sample Size</i>	<i>Acceptance No. (Permissible No. of Defectives)</i>
(1)	(2)	(3)	(4)
i)	Up to 100	8	0
ii)	101 to 150	13	1
iii)	151 to 300	20	2
iv)	301 to 500	32	3
v)	501 to 1 000	50	5
vi)	Above 1 000	80	7

## 7 MARKING

**7.1** Each package or picker (as applicable) shall have the following information suitably marked:

- Type of picker;
- Length (mm), width (mm), thickness (mm) and mass (g);
- Spindle hole (mm) (in case of overpick loom pickers) or slot width (mm) (in case of under pick loom pickers);
- Side of the picker to be used first;
- Name or trade-mark of the manufacturer; and
- Number of pickers in the package.

## 7.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.

## 8 PACKING

The pickers shall be packed in a suitable package as detailed in the contract.

## ANNEX A

(Clause 2)

### LIST OF REFERRED STANDARDS

<i>IS No.</i>	<i>Title</i>
IS 1906 : 2023	Recommendation for shape and dimensions of 4B picker ( <i>third revision</i> )
IS 7043 : 1973	Specification for loom (fly) spindles

**ANNEX B***(Foreword)***COMMITTEE COMPOSITION**

Textile Machinery and Accessories Sectional Committee, TXD 14

<i>Organization</i>	<i>Representative(s)</i>
Central Manufacturing Technology Institute, Bengaluru	DR NAGAHANUMAIAN ( <b>Chairperson</b> )
Amritlakshmi Machine Works, Mumbai	SHRI N. K. BRAHMACHARI SHRI N. K. RAUT ( <i>Alternate</i> )
ATE Enterprises Private Limited, New Delhi	SHRI ABHIJIT KULKARNI SHRI ANIL KUMAR SHARMA ( <i>Alternate</i> )
Bajaj Industries Private Limited, Kolkata	REPRESENTATIVE
Bhowmick Calculator, Kolkata	SHRI GOUTAM BHOWMICK SHRI VIVEKANANDA BHOWMICK ( <i>Alternate</i> )
Central Manufacturing Technology Institute, Bengaluru	SHRI B. R. MOHANRAJ SHRI K. SARAVANAN ( <i>Alternate</i> )
Confederation of Indian Textile Industry, New Delhi	SHRI AJAY KUMAR
Dashmesh Jacquard and Powerloom Private Limited, Panipat	SHRI RAJMEET DHAMMU ( <i>Representative</i> )
HLL Lifecare Limited, Noida	SHRI AKHIL G. S. SHRI RATNAKAR GUPTA ( <i>Alternate</i> )
ICAR-Central Institute for Research on Cotton Technology, Mumbai	DR N. SHANMUGAM DR T. SENTHILKUMAR ( <i>Alternate</i> )
India ITME Society, Mumbai	SHRI PRASHANT MANGUKIA SHRIMATI SEEMA SRIVASTAVA ( <i>Alternate</i> )
Indian Jute Industries Research Association, Kolkata	SHRIMATI SAUMITA CHOUDHURY SHRI PARTHA SANYAL ( <i>Alternate</i> )
Indian Jute Mills Association, Kolkata	REPRESENTATIVE
Indian Textile Accessories and Machinery Manufacturers Association, Mumbai	SHRI N. D. MHATRE SHRI CHANDRESH SHAH ( <i>Alternate</i> )
Inspiron Engineering Private Limited, Ahmedabad	SHRI SANJAY KOWARKAR SHRI ANKUR SONI ( <i>Alternate</i> )
JCB Industries, Guwahati	SHRI DHRUBA SARMA SHRI ABHIJIT BHUYAN ( <i>Alternate</i> )
Kusters Calico Machinery Limited, Karjan	SHRI DEVANG PARIKH SHRI SHUBHASIS SUR ( <i>Alternate</i> )
Lakshmi Machine Works Limited, Coimbatore	MS KALPANA A. MS DIVYA V. ( <i>Alternate</i> )
Laxmi Shuttleless Looms Private Limited, Ahmedabad	SHRI KETAN SANGHVI
Ludlow Jute Limited, Kolkata	REPRESENTATIVE

<i>Organization</i>	<i>Representative(s)</i>
Ministry of Heavy Industries and Public Enterprises, Department of Heavy Industry, New Delhi	SHRI SANJEEV GUPTA SHRI S. SUNDAR ( <i>Alternate</i> )
National Safety Council, Navi Mumbai	SHRI LALIT R. GABHANE SHRI R. R. DEOGHARE ( <i>Alternate</i> )
Office of the Textile Commissioner, Mumbai	SHRI C. R. KALESAN SHRI JAGRAM MEENA ( <i>Alternate</i> )
Peass Industrial Engineers Private Limited, Navari	SHRI RAVI S. RAO SHRI JIGNESH B. PATEL ( <i>Alternate</i> )
Technocraft Industries India Limited, Mumbai	SHRI RAVINDER KUMAR SHRI DURADUNDESHWAR HIREMATH ( <i>Alternate</i> )
Textile Machinery Manufacturers Association, Mumbai	SHRI M. SHANKAR SHRI PRASHANT MANGUKIA ( <i>Alternate</i> )
The Bombay Textile Research Association, Mumbai	SHRI VIJAY GAWDE SHRI R. A. SHAIKH ( <i>Alternate</i> )
The Synthetic and Art Silk Mills Research Association, Mumbai	DR MANISHA MATHUR SHRI SANJAY SAINI ( <i>Alternate</i> )
The Textile Association (India), Mumbai	SHRI J. B. SOMA SHRI ASHOK JUNEJA ( <i>Alternate</i> )
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*Member Secretary*  
SHRI SWAPNIL  
SCIENTIST 'B'/ASSISTANT DIRECTOR  
(TEXTILES), BIS



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